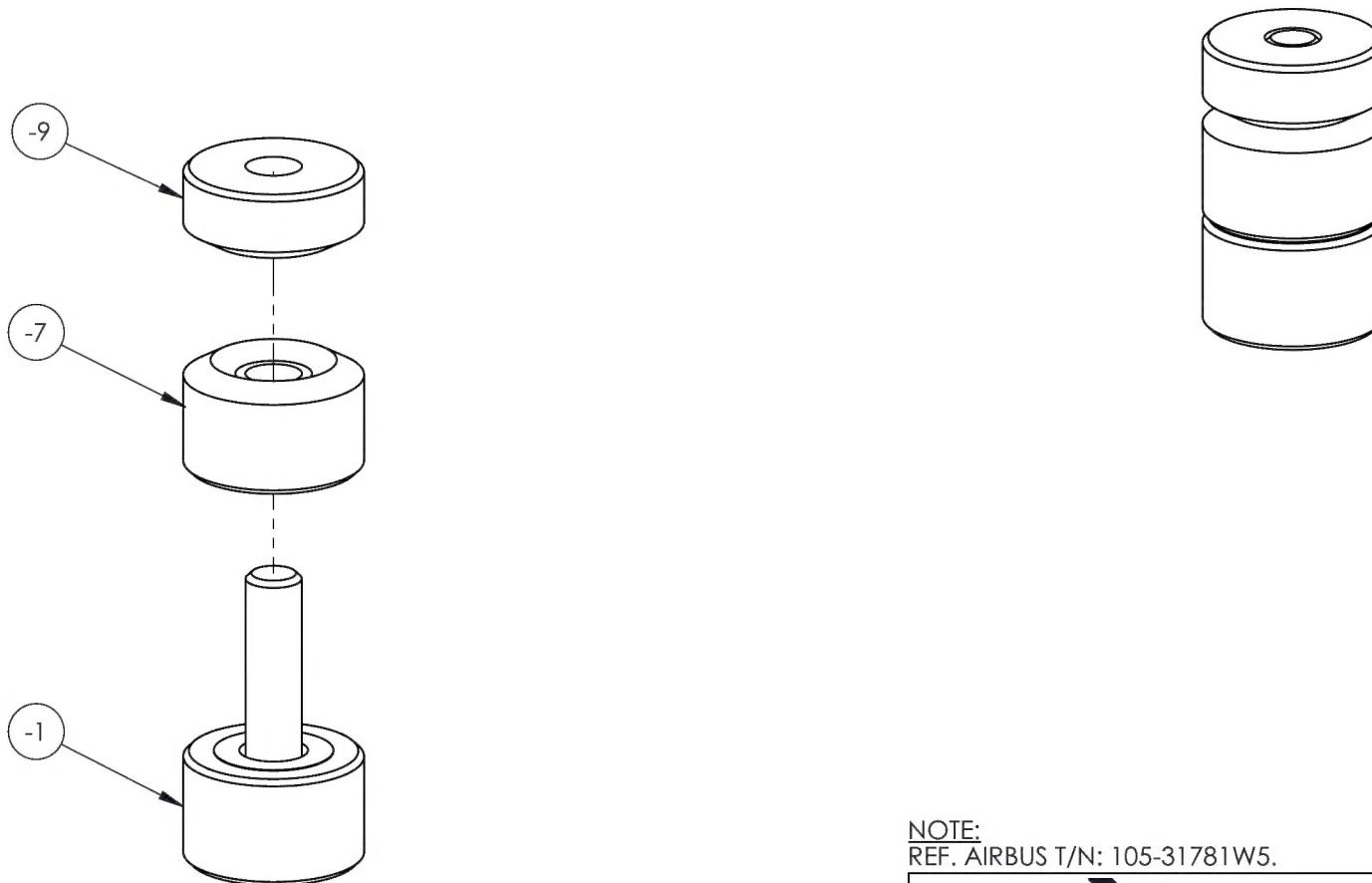


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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION.	11/11/2016	DPD	JAG



NOTE:
REF. AIRBUS T/N: 105-31781W5.

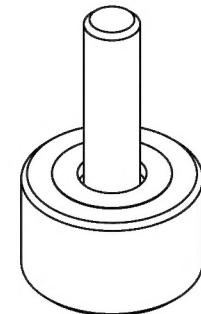
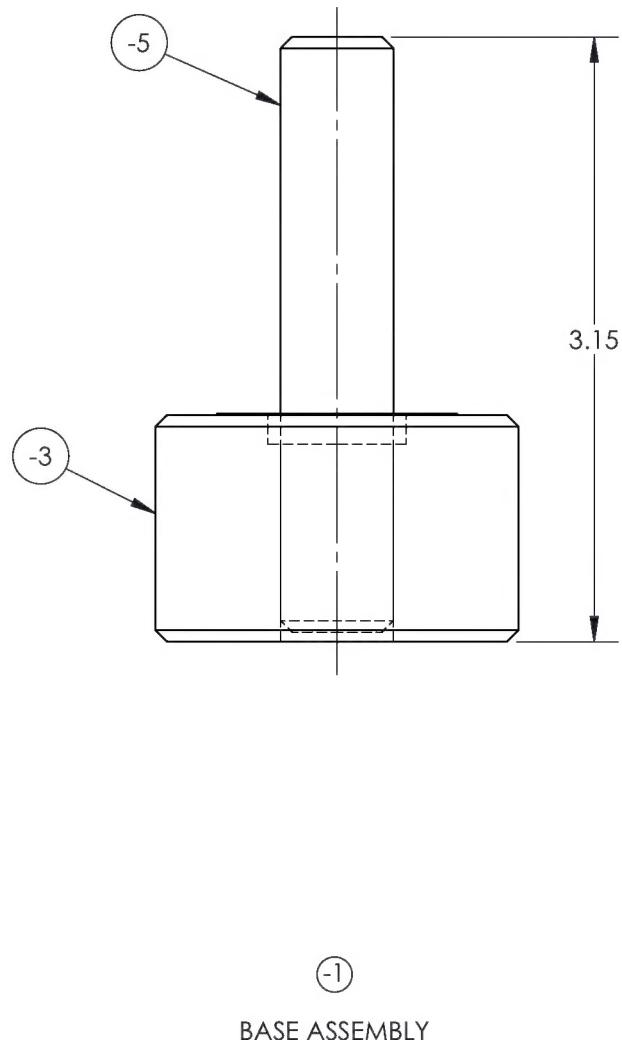


TITLE		STAKING TOOL
DWG NO.		RBE105-31781W5
REV		1
MATERIAL		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TREAT		.XXX ± .005 FRACTIONS ± 1/8
FINISH		.XX ± .01 ANGLES ± 5°
SPEC		X ± .1 SURFACES = 125 ✓
DRAWN BY:		DUERFELDT
CHECKED:		CLOUGH
OPPS APPR:		ANDERSON
QA APPR:		LINDSAY
APPROVED:		GILBERT H145
SCALE		1:2
DATE		8/19/2016
SHEET		1 OF 6

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
X		-1	1	BASE ASSEMBLY		O1		2
1		-3	1	BASE		O1		3
1		-5	1	BASE PIN		O1		4
		-7	1	PRESS		O1		5
		-9	1	STAKE		O1		6
ASSY -1							SCALE 1:2 DATE 8/19/2016 SHEET 1 OF 6	

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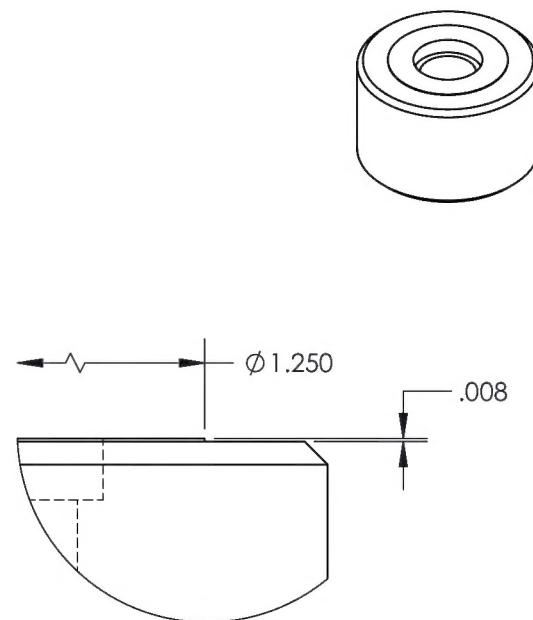
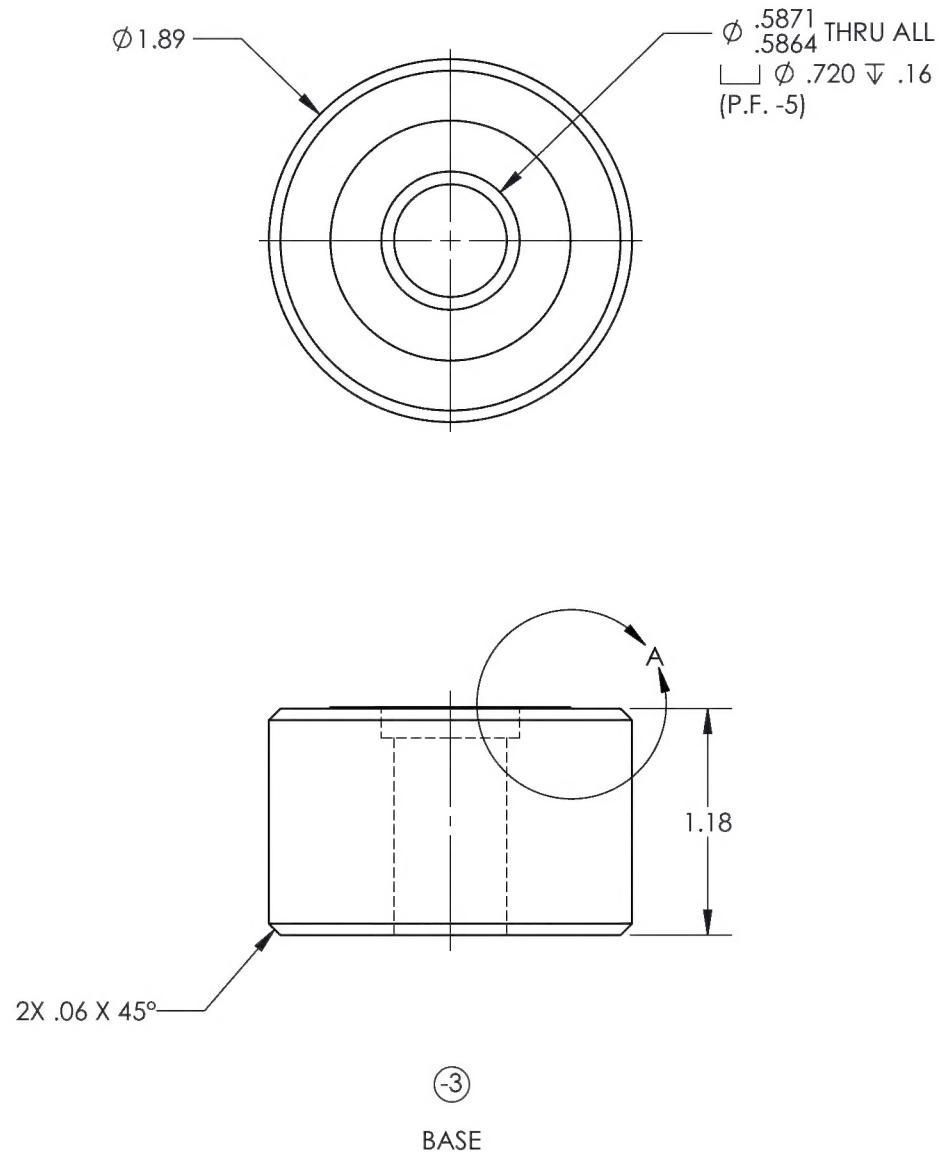
REV		ECR		DESCRIPTION			DATE	INITIAL	APPROVED
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DART AEROSPACE	
TITLE	
STAKING TOOL	
DWG NO. RBE105-31781W5-1 REV 1	
MAT'L	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT	.XXX ± .005 FRACTIONS ± 1/8
TREAT	.XX ± .01 ANGLES ± 5°
FINISH	X ± .1 SURFACES = 125 ✓
SPEC	ASTM B633 TYPE I SC 2
DRAWN BY:	DUERFELDT
CHECKED:	CLOUGH
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT H145
SCALE	1:1
DATE	8/19/2016
SHEET 2 OF 6	

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REV	ECR	REVISIONS	DESCRIPTION	DATE	INITIAL	APPROVED
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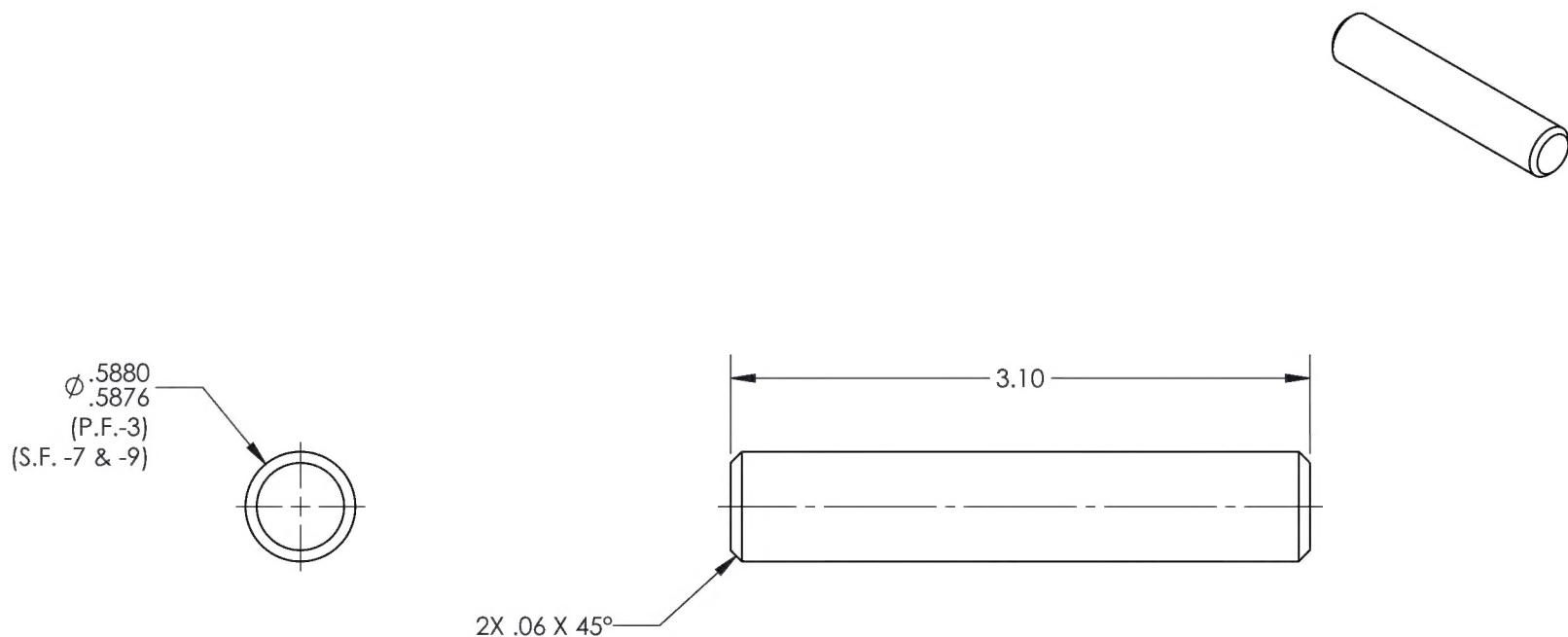


DETAIL A
SCALE 2 : 1

DART AEROSPACE	
TITLE	
STAKING TOOL	
DWG NO.	RBE105-31781W5-3
REV	1
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
.XXX ± .005 FRACTIONS ± 1/8	
.XX ± .01 ANGLES ± 5°	
X ± .1 SURFACES = 125 ✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
MAT'L	O1
HEAT	RC 50-60
TREAT	
FINISH	SEE -1
SPEC	
DRAWN BY:	DUERFELDT
CHECKED:	CLOUGH
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL	H145
SCALE	1:1
DATE	8/19/2016
SHEET 3 OF 6	

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REV		ECR		REVISIONS		
				DESCRIPTION		DATE
				INITIAL	APPROVED	

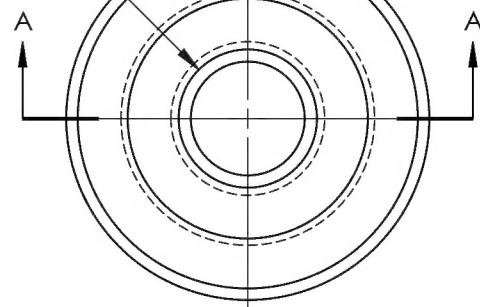


DART AEROSPACE	
TITLE	
STAKING TOOL	
DWG NO. RBE105-31781W5-5	
REV 1	
MAT'L O1 UNLESS OTHERWISE SPECIFIED HEAT RC 50-60 DIMENSIONS ARE IN INCHES TREAT .XXX ± .005 FRACTIONS ± 1/8 FINISH SEE -1 .XX ± .01 ANGLES ± 5° SPEC .X ± .1 SURFACES = 125 ✓	
DRAWN BY: DUERFELDT CHECKED: CLOUGH OPPS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT USED ON MODEL H145	
SCALE 1:1	DATE 8/19/2016
SHEET 4 OF 6	

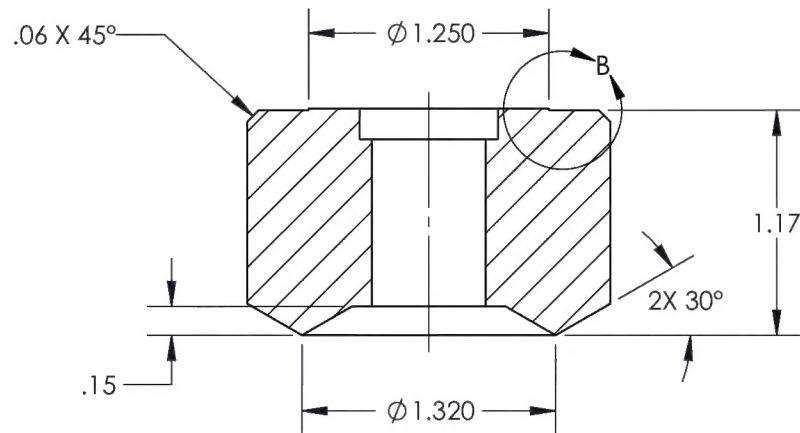
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REV	ECR	REVISIONS	DESCRIPTION	DATE	INITIAL	APPROVED
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$\phi .5943$
 $.5915$ THRU ALL
 $\square \phi .720 \mp .16$
(S.F. -5)



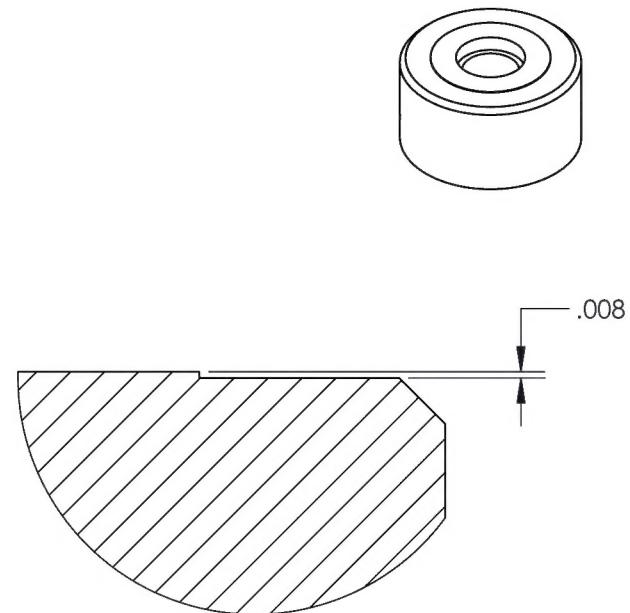
$\phi 1.89$



SECTION A-A

(-7)

PRESS



DETAIL B
SCALE 4 : 1

DART
AEROSPACE

TITLE	
DWG NO. RBE105-31781W5-7	
REV 1	
MATERIAL O1	
HEAT TREAT RC 50-60	
FINISH ZINC PLATE	
SPEC ASTM B633 TYPE I SC 2	
DRAWN BY:	DUERFELDT
CHECKED:	CLOUGH
OPPS APPR.:	ANDERSON
QA APPR.:	LINDSAY
APPROVED:	GILBERT
SCALE 1:1	USED ON MODEL
DATE 8/19/2016	H145
SHEET 5 OF 6	

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES

.XXX ± .005 FRACTIONS ± 1/8

.XX ± .01 ANGLES ± 5°

X ± .1 SURFACES = 125 ✓

1. BREAK ALL SHARP EDGES

.015 x 45° OR .015R

2. DIMENSIONAL LIMITS APPLY

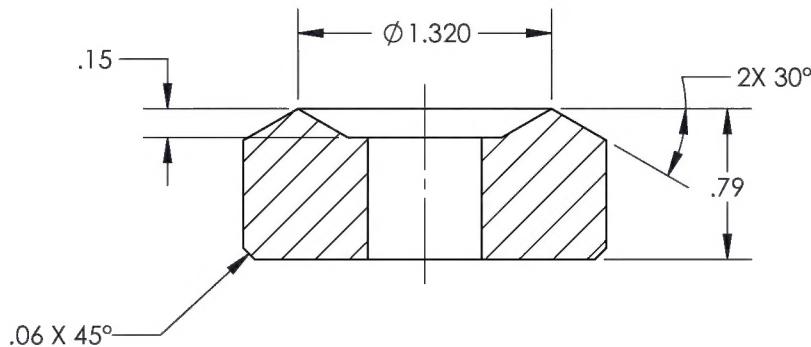
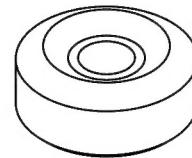
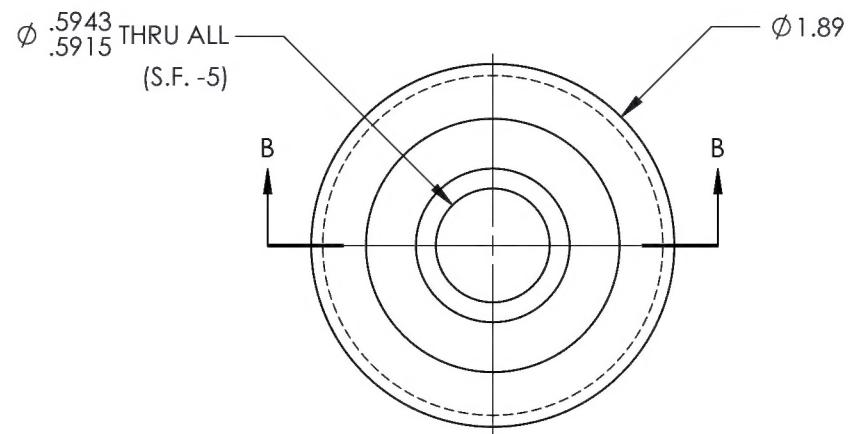
AFTER PLATING

3. INTERPRET DIM AND TOL PER

ASME Y14.5M-2009

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REV	ECR	REVISIONS	DESCRIPTION	DATE	INITIAL	APPROVED
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SECTION B-B

(-9)

STAKE

DART AEROSPACE	
TITLE	
DWG NO.	
RBE105-31781W5-9	
REV	1
UNLESS OTHERWISE SPECIFIED	
DIMENSIONS ARE IN INCHES	
.XXX ± .005 FRACTIONS ± 1/8	
.XX ± .01 ANGLES ± 5°	
.X ± .1 SURFACES = 125 ✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
USED ON MODEL	
H145	
SCALE	1:1
DATE	8/19/2016
SHEET 6 OF 6	